

Work Order ID 155183

Monday, January 09, 2017 8:06:36 PM

155183

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for Pull Test ok

Item ID: D5350-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Beam Assembly
 Start Date: 01/09/2017 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 01/13/2017 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5350	<i>Rev C</i>								
110		0.00							
110									
Small Fab	Memo	0.04							
Small Fab	ASSEMBLE AS PER DWG SEE NOTE 9 FOR TORQUE SPEC ON NUTS								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location:	0.00							
130									
Packaging	Memo	0.00							
Packaging									

POSITIVE RECALL
EFFECTIVE 17-01-15 **AUTH** 9
RELEASED DATE

[Signature]
 RD17-1016-1

DAS
36
9-8

DAS
9
9-89

DAS
9
9-89

Pull Test

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Item ID: D5350-043**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Aft Beam Assembly**Start Date:** 01/09/2017 **Start Qty:** 1.00***1*****Cust Item ID:****Required Date:** 01/13/2017 **Req'd Qty:** 1.00***1*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.02

Quality Control

Picklist Print

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Work Order ID: 155183

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Parent Item: D5350-043

D5350-043

Parent Item Name: Aft Beam Assembly

Start Date: 01/09/2017

Required Date: 01/13/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.12.11 NEW ISSUE DD VERF:JLM IPP
REV:B 16.01.25 rev.a dwg DD VERF:JLM IPP REV:C
16.06.30 DWG REV.B DD VERF:JLM IPP REV:D 17.01.09
DWG REV.c DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2690-11 *D2690-11* Lanyard Assembly		Manufactured	No				Each	0.0000	**	2		DAS 30 9-89	JAN 11 2017
D3917-3 *D3917-3* Washer		Manufactured	No				Each	69.0000	**	2		DAS 30 9-89	JAN 11 2017
Location ST058 151081 152988 Loc Qty 69 16 53 Loc Code													
D5346-3 *D5346-3* Bushing		Manufactured	No				Each	0.0000	**	4			
D5350-3 *D5350-3* Aft Beam		Manufactured	No				Each	0.0000	**	1			
D5350-5 *D5350-5* Adapter		Manufactured	No				Each	0.0000	**	1		DAS 30 9-89	JAN 11 2017

Picklist Print

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Parent Item: D5350-043

D5350-043

Parent Item Name: Aft Beam Assembly

Start Date: 01/09/2017

Required Date: 01/13/2017

Start Qty: 1.00

Required Qty: 1.00

AN310-4 Purchased No

Each 103.0000 1

AN310-4

Nut

**

DAS
30
9-89

JAN 11 2017

Location

Loc Qty

Loc Code

GA

25

M127815

25

OVER007

40

M135704

0

M136295

40

ST331

38

M135704

3

M135999

35

AN4-20 Purchased No

Each 0.0000 1

AN4-20

Bolt

**

DAS
30
9-89

JAN 11 2017

MS17984-C412

Purchased No

Each 6.0000 2

MS17984-C412

Pin, Quick Release

**

DAS
30
9-89

JAN 11 2017

Location

Loc Qty

Loc Code

ST315

6

m130358

1

m135297

5

MS24665-151 Purchased No

Each 190.0000 1

MS24665-151

Cotter Pin

**

DAS
30
9-89

JAN 11 2017

Location

Loc Qty

Loc Code

GA

60

m128401

60

ST289

130

m135274

30

m136444

100

Picklist Print

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Work Order ID: 155183

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Parent Item: D5350-043

D5350-043

Parent Item Name: Aft Beam Assembly

Start Date: 01/09/2017

Required Date: 01/13/2017

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0416J

Purchased

No

Each

3,949.000

2

DAS
33C
088

JAN 11 2017

NAS1149D0416.J

**

WASHER

Location

Loc Qty

Loc Code

GA

7

m131511

7

ST260a

2492

m131511

2492

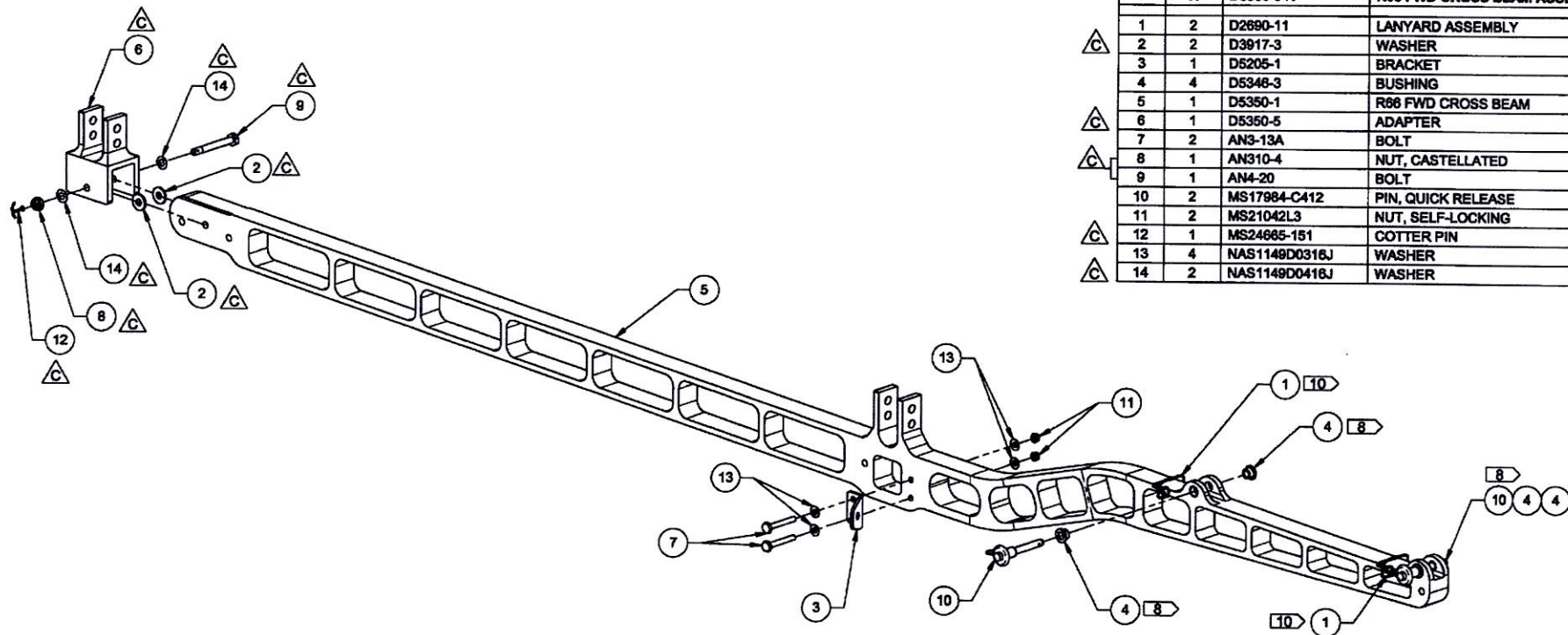
ST264

1450

m131511

1450

2



ITEM	QTY	P/N	DESCRIPTION
	X	D5350-041	R66 FWD CROSS BEAM ASSEMBLY
1	2	D2690-11	LANYARD ASSEMBLY
2	2	D3917-3	WASHER
3	1	D5205-1	BRACKET
4	4	D5346-3	BUSHING
5	1	D5350-1	R66 FWD CROSS BEAM
6	1	D5350-5	ADAPTER
7	2	AN3-13A	BOLT
8	1	AN310-4	NUT, CASTELLATED
9	1	AN4-20	BOLT
10	2	MS17984-C412	PIN, QUICK RELEASE
11	2	MS21042L3	NUT, SELF-LOCKING
12	1	MS24865-151	COTTER PIN
13	4	NAS1149D0316J	WASHER
14	2	NAS1149D0416J	WASHER

D5350-041 R66 FWD CROSS BEAM ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 5.98 lbs
- 8) PRESS FIT D5346-3 INTO D5350-1
- 9) TORQUE MS21042L3 NUTS TO 20-25 in-lb (2.3-2.8 N-m)
- 10) ASSEMBLE D2690-11 WITH MS17984-C412 AS SHOWN

C	REDESIGN -1/31-0411-043 (ZN A4-1, A4-2, A4-3, A4-4); ADDED -5 (ZN A4-5) & NOTE 10 & 11 (ZN A5-3, A5-4); REVISE BOM% ZN (D3-1, D3-2)	RF	16.11.18
B	REDESIGN -1/31-0411-043 (ZN A4-1, A4-2, A4-3, A4-4)	RF	16.05.24
A	NEW ISSUE	RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	WK		
MFG. APPR.	JFS		
APPROVED	HS		
DE APPR.	DS		
DATE	16.11.18		

APPROVED

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D5350

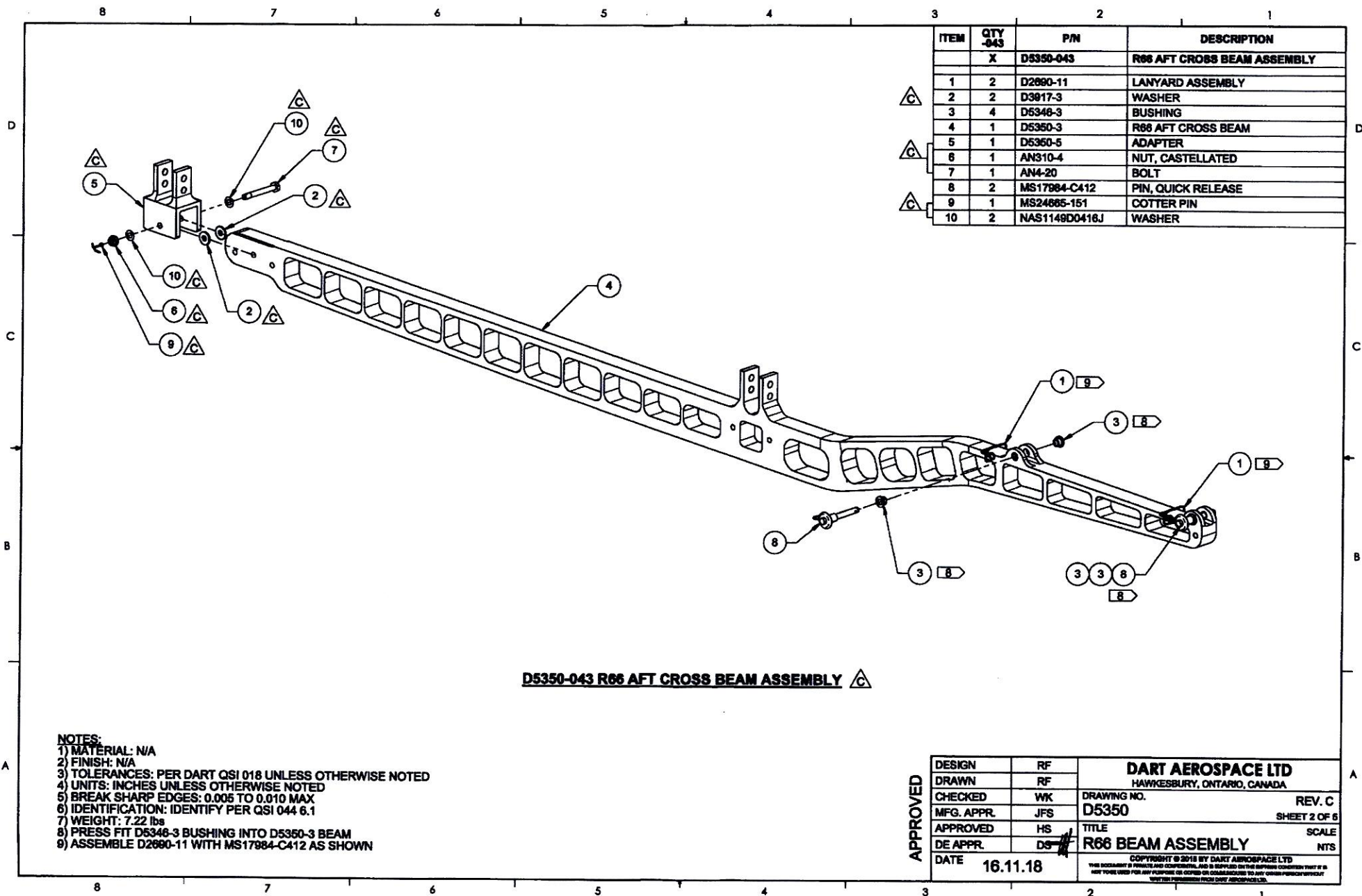
TITLE
R66 BEAM ASSEMBLY

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REV. C
SHEET 1 OF 5

SCALE
NTS



ITEM	QTY -043	P/N	DESCRIPTION
	X	D5350-043	R66 AFT CROSS BEAM ASSEMBLY
1	2	D2690-11	LANYARD ASSEMBLY
2	2	D3917-3	WASHER
3	4	D5346-3	BUSHING
4	1	D5350-3	R66 AFT CROSS BEAM
5	1	D5350-5	ADAPTER
6	1	AN310-4	NUT, CASTELLATED
7	1	AN4-20	BOLT
8	2	MS17984-C412	PIN, QUICK RELEASE
9	1	MS24665-151	COTTER PIN
10	2	NAS1149D0416J	WASHER

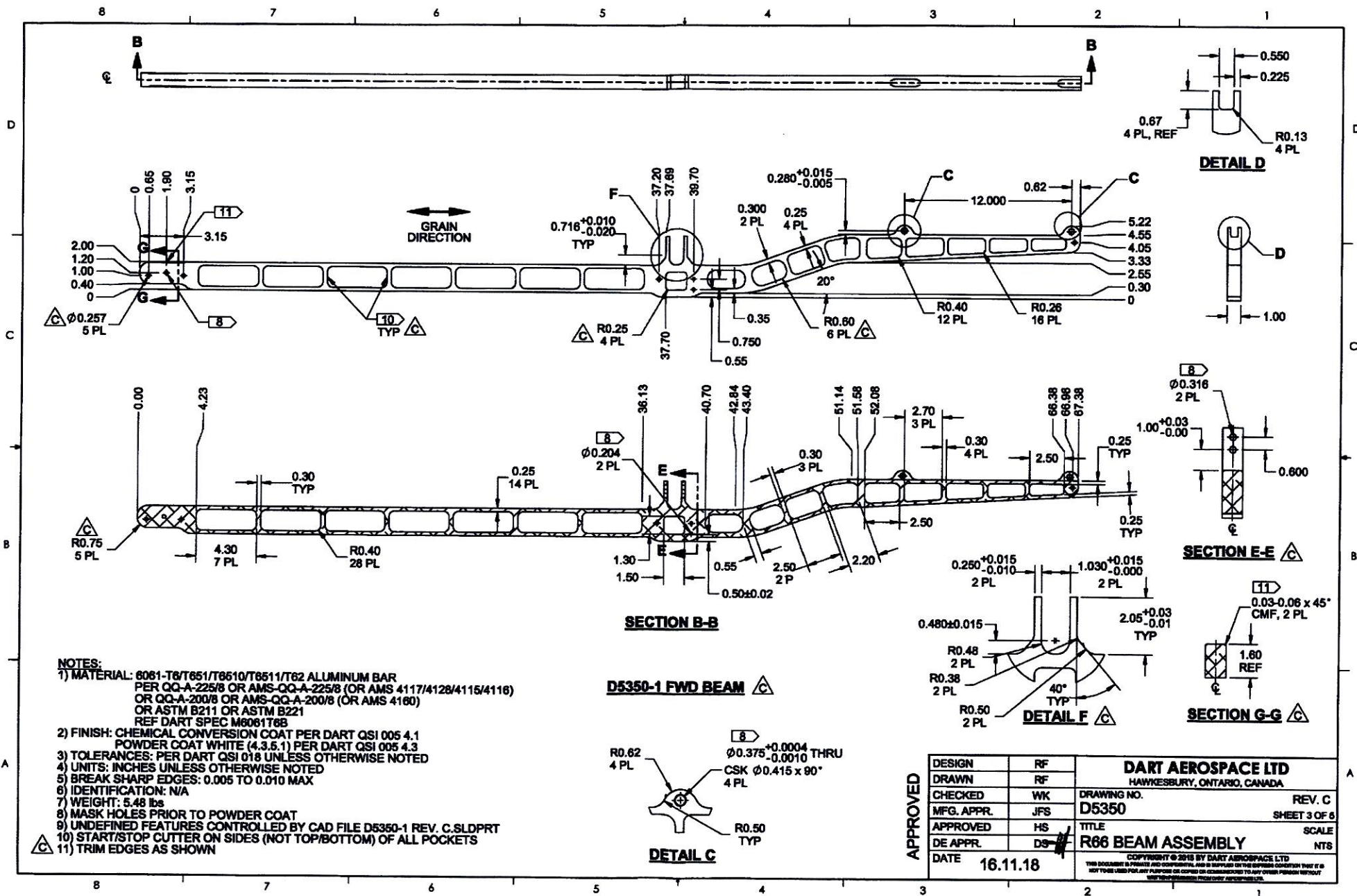
D5350-043 R66 AFT CROSS BEAM ASSEMBLY

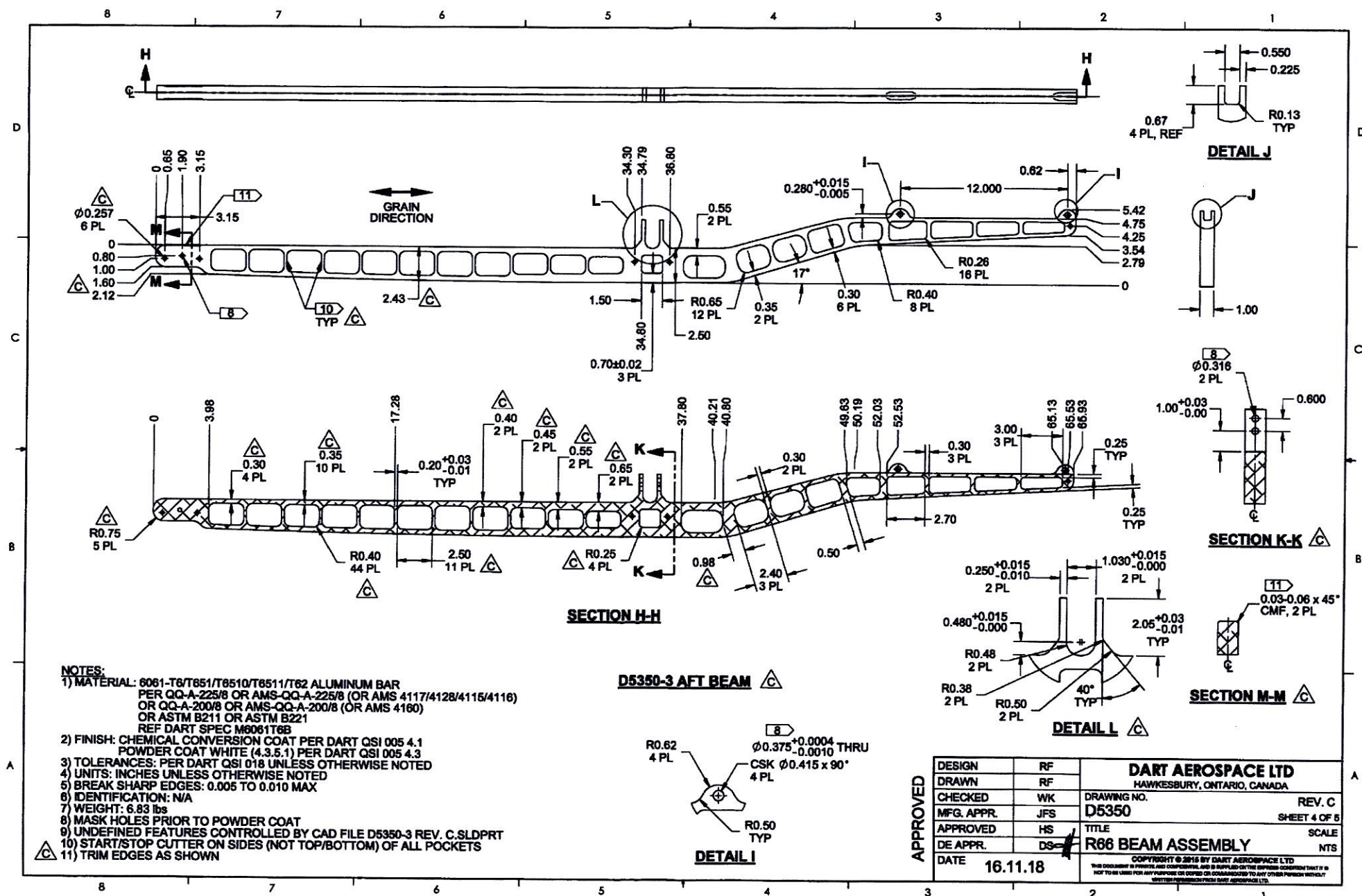
NOTES:

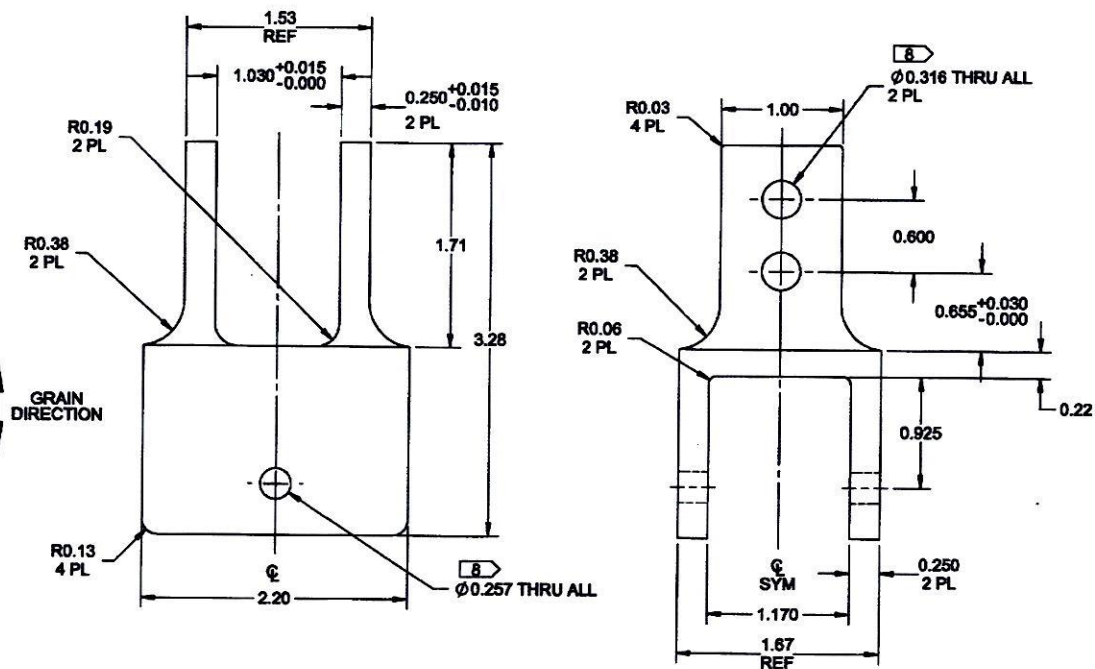
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 7.22 lbs
- 8) PRESS FIT D5346-3 BUSHING INTO D5350-3 BEAM
- 9) ASSEMBLE D2690-11 WITH MS17984-C412 AS SHOWN

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	WK	DRAWING NO. D5350	REV. C
MFG. APPR.	JFS	SHEET 2 OF 6	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66 BEAM ASSEMBLY	NTS
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D5350-5 ADAPTER

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	WK	DRAWING NO.	REV. C
MFG. APPR.	JFS	D5350	SHEET 5 OF 5
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DE APPR.	DSC	R66 BEAM ASSEMBLY	NTS
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